

Date: Monday, 11/05/2009 1:21:15 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW LUG
Job Number : 47855	
Estimate Number : 11217	
P.O. Number :	Part Number : D34041
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3404 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 47517	Material :
Written By :	Due Date : 22/05/2009 Qty: 20 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:A 05.09.01 New issue KJ/JLM Est rev B 09.01.28 new geometry rev.C EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750X2500	304 BAR .750 X 2.50
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(20)

Comment: Qty.: 0.2406 f(s)/Unit Total : 4.8111 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M110777

H.A 09/05/24

2.0	BAND SAW	BAND SAW
-----	----------	----------



(20)

Comment: BAND SAW
 Cut blank: 2.750" long

H.A 09/05/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(20)

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: C Folio Rev: C

2-Deburr

H.A 09/05/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: GHW LUG

Job Number: 47855

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/05/25

(20)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

09/05/25

(20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



mf

09-05-25

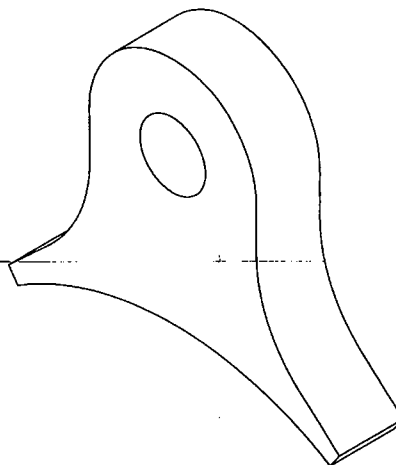
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3404-1 GHW LUG

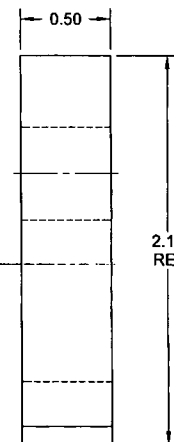
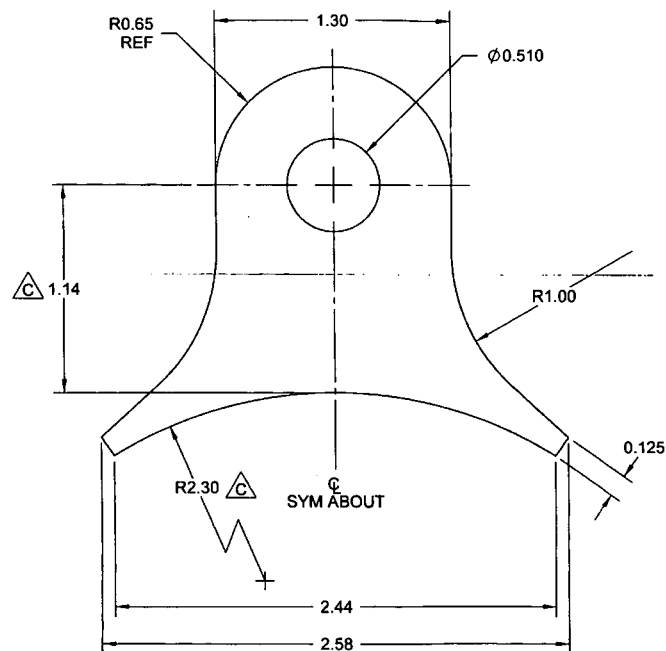
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08/12/13 NW

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WITHOUT NOTICE
WORK ORDER
NO. 41855

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B8-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.06.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3404	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG	NTS	
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
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DE APPR.		GHW LUG	NTS
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